

Date: Monday, 22/10/2007 2:17:22 PM  
User: Linda Lacelle

## Process Sheet

28.01.31  
H Split 302 12-12

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 35298 *4*  
Estimate Number : 12884  
P.O. Number :  
This Issue : 22/10/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : SMALL /MED FAB  
Previous Run : 35032  
Written By :  
Checked & Approved By :  
Comment : Est Rev:A New Issue 07.05.24 EC  
Est Rev B ECN 987 07.10.09 EC verified by DD

Drawing Name : ARM  
Part Number : D3560044  
Drawing Number : D3560 UNDER REVIEW  
Project Number : N/A  
Drawing Revision : C  
Material :  
Due Date : 29/10/2007 Qty: 14 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total: 19.0365 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: 21106132 *07/11/30* (14)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long *07/11/30* (14)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: *AS* & Dwg D3560 Rev: *C*

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560 *07/12/08* *S.F* *07/12/07*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE *07/12/08* *S.F* *07/12/07*

5.0 QC8 SECOND CHECK

Comment: SECOND CHECK *07.12.07* (14)





User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35298

Part Number: D3560044

Job Number:



Seq. #:	Machine Or Operation:	Description :
1	1000	1000
2	1000	1000
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100	1000	1000

6.0	D35921	PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

PLATE 3 35331 = 5

208.01.31

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

**STEP:**

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch ( 600°)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

08.02.04 5

8.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

2021/05 (+5) (off)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 03-02-05 (5)

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAN 08:02:05 (5)





Date: Monday, 22/10/2007 2:17:22 PM

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35298

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.02.05

5

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

Spacer

batch: B35330

08/02/06 (5)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

08/02/06 (5)

14.0

QC5

INSPECT WORK TO CURRENT STEP



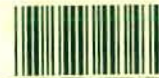
Comment: INSPECT WORK TO CURRENT STEP

08/02/06 (5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

08.02.06 5

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/08 (5)

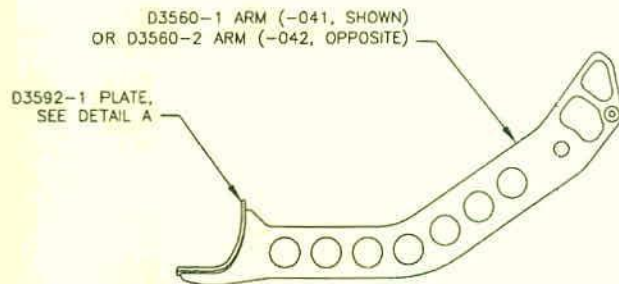
Job Completion



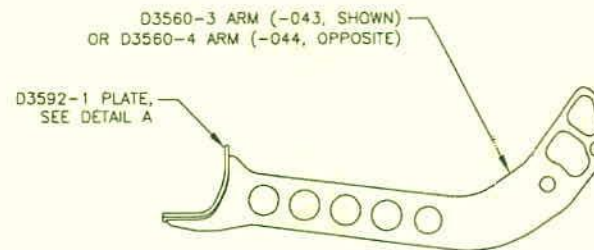
2008/2/06 (5)

W

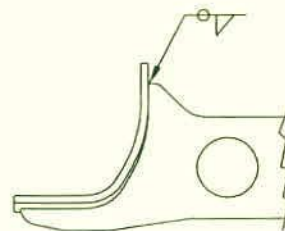
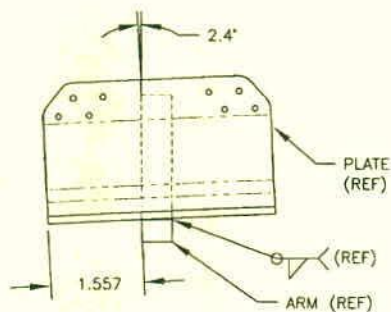




D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



#### GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.10.22 DE  
**UNDER REVIEW**

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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. WARRICKSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560 REV. C SHEET 1 OF 3
DATE	TITLE	SCALE
07.06.19	ARM WELDMENT	1:4









SCALE 1:1



THE  
JOURNAL  
OF  
THE  
AMERICAN  
MUSEUM  
OF  
NATURAL  
HISTORY  
NEW YORK

VOLUME 100  
PART 1  
1910

CONTENTS

1. The American Museum of Natural History, 1910

2. The American Museum of Natural History, 1910

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37. The American Museum of Natural History, 1910

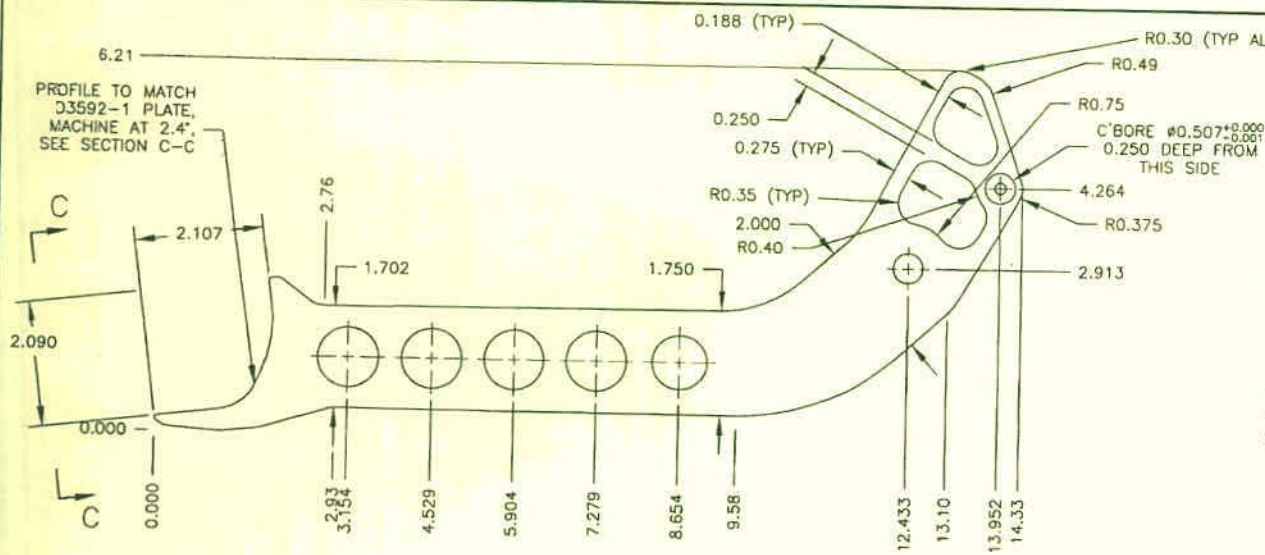
38. The American Museum of Natural History, 1910

39. The American Museum of Natural History, 1910

40. The American Museum of Natural History, 1910

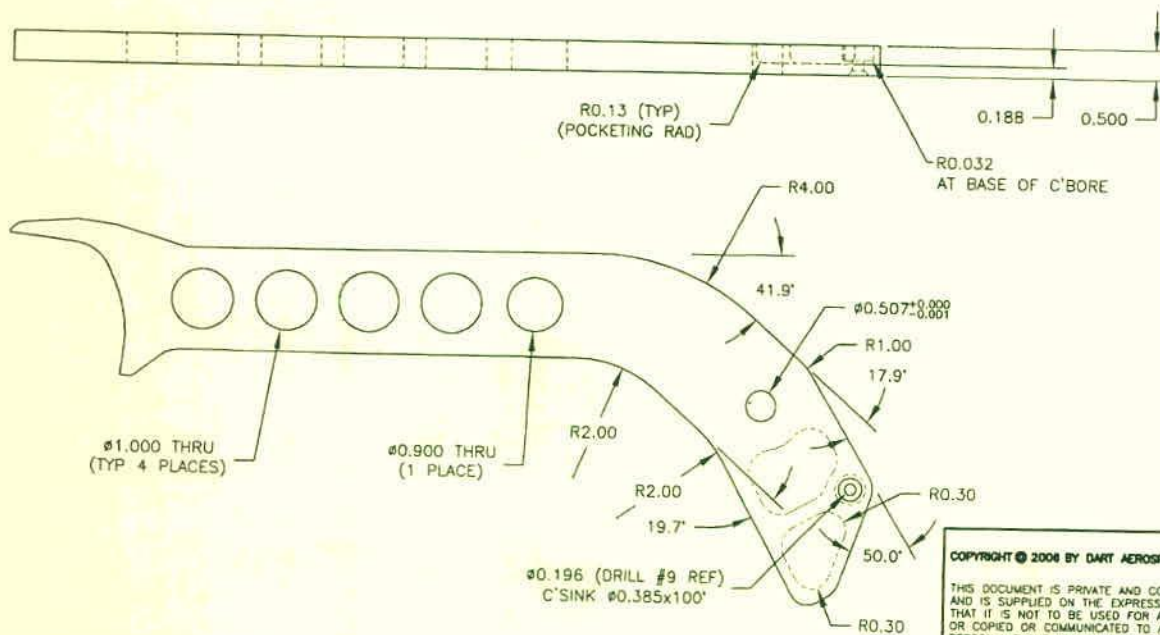
41. The American Museum of Natural History, 1910

42. The American Museum of Natural History, 1910

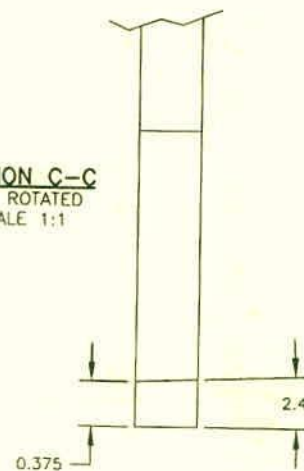


**D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



**SECTION C-C**  
VIEW ROTATED  
SCALE 1:1



**RELEASED**  
07.06.19

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DATE 07.06.19		TITLE ARM WELDMENT		SCALE 1:2	





35298

☒ First Article    ☐ Prototype

Measured by: <i>JF</i>	Audited by: <i>Jm</i>	Prototype Approval:	N/A
Date: <i>07/12/07</i>	Date: <i>07/12/08</i>	Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD

